

Work Order ID 82050

March-22-12 10:35:10 AM

82050

Page 1

Item ID: D2572 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd In 205
 Start Date: 22/03/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2572	Rev E								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program Batch No. <u>82050</u> Double check by: <u>[Signature]</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp								
110	CONVENTIONAL MILLING MACHINE	0.00							
110									
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine keyway as per dwg D2571 & D2572								

[Signature] 12-04-01

8 [Signature] 12/04/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82050***82050***

Page 2

March-22-12 10:35:10 AM

Item ID: D2572

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Fwd In 205

Start Date: 22/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

8 0 36
12/04/04

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

D.A 12/04/04

8 0

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

8x0 m/12/24/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Dart Aerospace Ltd

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Page 4

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Item ID: D2572

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd In 205

Start Date: 22/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

12/4/10 

12-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

March-22-12 10:35:13 AM

Page 1

Work Order ID: 82050

82050

Parent Item: D2572

D2572

Parent Item Name: Saddle, Fwd In 205

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-005		Manufactured	No			100	Each	60.0000	1	8			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D6101-005

Saddle Billet

**

86 12/03/29

Location

Loc Qty

Loc Code

MAT041

28

71721

1

76838

7

79588

20

MAT044

28

79874

28

MAT045

1

74507

1

MAT046

3

66966

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

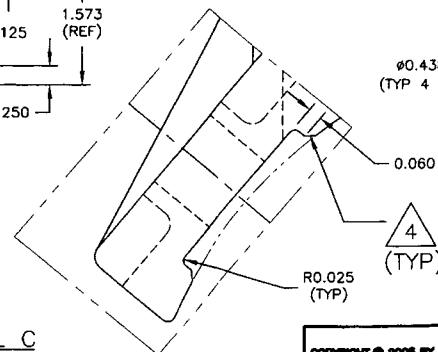
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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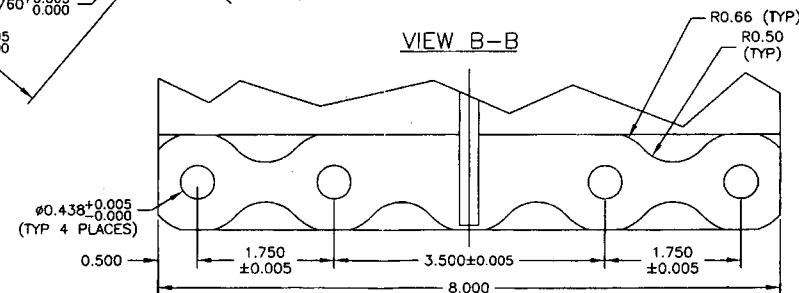


MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
| 1 | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
| 2 | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
| 3 | CHAMFER 0.063 x 45° ALL AROUND |
| 4 | CHAMFER 0.033 x 45° (SEE DETAIL C) |



DETAIL C
SCALE 2:1



DESIGN	DRAWN BY		DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
DS	PH		
CHECKED 	APPROVED 	DRAWING NO. D2572	REV. SHEET 1 OF
DATE 05.07.13	TITLE INNER FWD SADDLE		SCALE 2:

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 82050 MLU

nos/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 82050
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.749	1.75	1.749	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.749	1.749	1.749		
E	7.990	8.010		8.003	8.002	8.002	8.002		
F	0.490	0.510		.501	.498	.504	.5		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.5015	.5005	.5015	.500		
J	1.174	1.184		1.178	1.179	1.178	1.179		
K	0.558	0.578		.569	.567	.569	.570		
L	1.174	1.184		1.179	1.178	1.18	1.179		
M	1.490	1.500		1.495	1.494	1.496	1.496		
N	2.495	2.505		2.5	2.499	2.499	2.5		
O	3.869	3.879		3.871	3.870	3.871	3.873		
P	0.115	0.135		.126	.128	.126	.126		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.250	.252	.251	.251		
S	0.115	0.135		.130	.130	.128	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.958	2.960	2.960		
V	0.230	0.250		.242	.239	.241	.241		
W	0.115	0.135		.133	.132	.133	.132		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.761	.761	.761	.761		
Z	0.352	0.372		.360	.364	.364	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.622	.623	.621		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.248	.248	.247		
AE	1.375	1.395		1.386	1.388	1.387	1.387		
AF	0.115	0.135		.134	.134	.130	.130		
AG	0.240	0.280		.250	.252	.252	.253		
AH	0.240	0.260		.250	.248	.252	.249		
AI	2.000	2.020		2.005	2.006	2.004	2.005		
AJ	0.023	0.043							
Accept/Reject									

Measured by:	RS / BL
Date:	12-04-01

Audited by:	H.A
Date:	12/04/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 82050
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

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				15	16	17	18		
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B	1.745	1.755		1.75	1.75	1.75	1.75		
C	3.495	3.505		3.5	3.5	3.5	3.5		
D	1.745	1.755		1.75	1.75	1.75	1.75		
E	7.990	8.010		8.002	8.002	8.002	8.003		
F	0.490	0.510		.495	.498	.502	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.499		
J	1.174	1.184		1.181	1.179	1.178	1.178		
K	0.558	0.578		.569	.569	.570	.570		
L	1.174	1.184		1.177	1.178	1.177	1.180		
M	1.490	1.500		1.496	1.496	1.496	1.496		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.871	3.873	3.872	3.874		
P	0.115	0.135		.126	.128	.126	.127		
Q	0.115	0.135		.126	.131	.131	.131		
R	0.240	0.260		.251	.253	.252	.253		
S	0.115	0.135		.135	.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.239	.240		
W	0.115	0.135		.132	.132	.132	.130		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.761	.761	.761	.761		
Z	0.352	0.372		.361	.362	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	.623	.623	.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.247	.245	.245		
AE	1.375	1.395		1.387	1.390	1.389	1.389		
AF	0.115	0.135		.128	.128	.128	.128		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.249	.250	.250	.247		
AI	2.000	2.020		2.004	2.007	2.006	2.005		
AJ	0.023	0.043							
Accept/Reject									

Measured by:	ET 136
Date:	12.04.01

Audited by:	B.A
Date:	12/04/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJJLM	